

Date: Monday, 12/01/2009 2:30:37 PM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services				Drawing Name	: SPACER		
Job Number	: 44567				Part Number	: D30661		
Estimate Number	: 10383				Drawing Number	: D3066 REV.B		
P.O. Number	:				Project Number	: N/A		
This Issue	: 12/01/2009 S.O. No. :				Drawing Revision	: B		
Prsht Rev.	: NC				Material	:		
First Issue	: / / Type : SMALL /MED FAB				Due Date	: 30/01/2009 Qty: 60 Um: Each		
Previous Run	: 44329							
Written By	:							
Checked & Approved By	: <u>JUL 09. 01. 12</u>							
Comment	: Est:C 02.11.01 Incorporated D3066-1 IPP KJ/RF Est Rev:B Now M6061-T6 06-06-23 JLM							

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M6061T6S080	6061-T6 .080 Sheet	
		<i>MAT NOT PULLED</i>	
		Comment: Qty.: 0.0992 sf(s)/Unit Total : 5.9535 sf(s) Material: 6061-T6 0.080" thick (M6061T6S.080) Batch: <u>110254</u> <u>HB 9-3-4</u>	
2.0	WATER JET	FLOW WATER JET	
		Comment: FLOW WATER JET 1-Cut as per Dwg D3066 Dwg Rev: <u>B</u> <u>HB 9-3-4</u> Prog Rev: <u>B</u>	
		2-Deburr if necessary <u>HB 9-3-4</u>	
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		<u>HB 9-3-4</u>	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	
4.0	QC8	SECOND CHECK	
		<u>S 09/03/09</u> <u>X60</u> <i>counts</i>	
		Comment: SECOND CHECK	
5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1	
		<u>MN/BY</u> <u>09/03/09</u>	
		Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005.4.1	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Seq. #: Machine Or Operation:

Description :

6.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



SC

Comment: INSPECT CHEMICAL CONVERSION COAT

7.0 PACKAGING 1

PACKAGING RESOURCE #1



SP

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

9/3/10
cel

8.0 QC21

FINAL INSPECTION/W/O RELEASE



09/03/11 gJ

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF

09-03-11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	H4567
Description: Spacer	Part Number:	D3066-1
Inspection Dwg: D3066	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

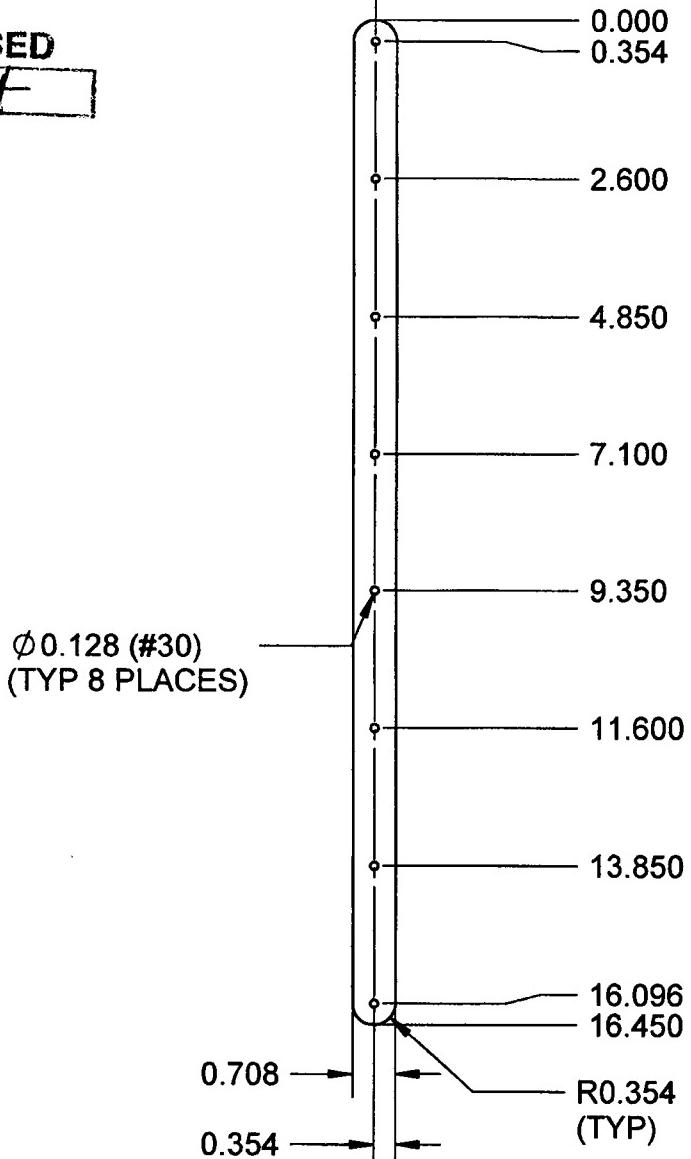
X First Article Prototype

Measured by: KB	Audited by: S	Prototype Approval:	N/A
Date: 9-3-04	Date: 09/05/05	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue P/O D3065-041	KJ/RF	
B	06.06.23	Dwg Rev. changed	KJ/JLM	<i>[Signature]</i>

DART

DESIGN <i>CP</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>SM</i>	DRAWING NO. D3066	REV. B SHEET 1 OF 1
DATE 06.05.29		TITLE SPACER	SCALE 1:3
A	02.09.11	NEW ISSUE	
B	06.05.29	ADD 6061-T6 MATERIAL	

RELEASED*06.06.20 -f***D3066-1 SPACER**

- 1) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027) 0.080" THICK
(REF DART SPEC M6061T6S.080)
OR
5052-H32/H34 (PER QQ-A-250/8 OR AMS 4016) 0.080" THICK
(REF DART SPEC. M5052H32S.080)
 - 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
 - 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
 - 4) PART IS SYMMETRIC ABOUT CENTERLINE
 - 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 6) ALL DIMENSIONS ARE IN INCHES
- SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *H451e1*

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